

Work Order ID 69872

Tuesday, May 24, 2011 8:24:56 AM



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 5/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-05-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3492

C

IIN-D350-636

H

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

E. Schick

for BG 11-6-16

69872

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

1



JB 11/06/02

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004
A/R Aluminum Rod batch: ☐ *M117456**BE 11/06/02*
BB 11/06/03

12-Grind welds flush as per Dwg D2750

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

0.00

Memo

8 u106103

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

8 u106103

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

Wh
u/06/06

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*DP**11-6-6*

W/O:		WORK ORDER CHANGES					
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Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160



Skidtubes

Skidtubes

Skidtubes

Memo

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291 batch: 116945 ☐☐☐exp. date: 12/2/158- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)A/R ☐☐☐ Aluminum Rod batch: M117456 BE 11/06/07

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

①

BE 11/06/06

BE 11/06/07
BE 11/06/08

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

12-Deburr holes

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8/10/09

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/09



BB

11/06/08



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
	HandFinish	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat	0.00							
Powder Coating	Memo START TIME: 1:40 OVEN TEMPERATURE: 320 FINISH TIME: 2:10	0.00							
210	QC3- Inspect Part Finish	0.00							
	QC	0.00							
Quality Control	Inspect for foreign object per QSI 024								

1X ~~QSI~~ 11/06/14

1X ~~QSI~~ 11/06/14

1 BR 11-6-15

M116964

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220



HandFinish

Hand Finishing

HandFinishing

Memo

1- Install inserts as per Dwg D2750

0.00

0.00

1 BR 11-6-15

230



HandFinish

Hand Finishing

HandFinishing

Memo

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: _____

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 117863

EXP DATE: 15-01

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: 114184

5-Coat all exposed fasteners with "LPS Procyon" batch: 114596

0.00

0.00

1 BR 11-6-15

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								

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Reference:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-011								
280	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Reo I

P 11/6/17 C

11/6/2017

MF
11-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Tuesday, May 24, 2011 8:25:03 AM

Page 1

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Parent Item: D350-636-011

Parent Item Name: Skidtube LH



Start Date: 5/24/2011

Start Qty: 1.00

Required Date: 5/30/2011

Required Qty: 1.00

Comments: IPP Rev: I 02-09-25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07-13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verf: EC
 IPP Rev: M 08-04-22 update steps 4, 13 DD verified by: EC
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec
 IPP Rev: O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf: EC IPP Rev: P 10-06-22 revise
 seq110 DD verf: EC IPP Rev: Q 10-10-01 as per IIN revH
 DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2594-3 O-Ring, 205 Skidtube		Manufactured	No			230	Each	1,020.000	8	8			
<div> <div>Location</div> <div>FP-A</div> <div>65518</div> <div>66952</div> </div> <div> <div>Loc Qty</div> <div>1020</div> <div>70</div> <div>950</div> </div> <div> <div>Loc Code</div> </div>													
D3492-1 Plug		Manufactured	No			230	Each	0.0000	8	8			
D3492-3 Plug		Manufactured	No			230	Each	0.0000	8	8			

710 - D

69531

69822

BL 11-6-15.

8. BL 11-6-15.

W/O: 69872		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-6-15	230	PERMANENT CHANGE. O'RING WAS 164-10. BE FOR REMOVE FROM W-ORDER	BY	11-6-15			

Part No: D350-636-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

266.0000

8

8



O-RING

Location

Loc Qty

Loc Code

FP

80

117460 ✓

80

FP-A

186

110915

139

115589

47

8 BL 11-6-15.

AN960JD816

Purchased

No

250

Each

43.0000

2

2



1/2" washer, Alum

Location

Loc Qty

Loc Code

FP-A

43

106043

43

2

D2744

Manufactured

No

110

Each

26.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG002

26

62715

2

65086

24

1

D2600-3-BENT

Manufactured

No

110

Each

14.0000

1

1



Extrusion Bent

Location

Loc Qty

Loc Code

LG

14

66875

8

68137

6

1

BE 11/06/02

Tuesday, May 24, 2011 8:25:03 AM

Shop Packet Print

Page 2

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Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160 Each

162.0000 8 8



Crossbolt Spacer



BE 11/06/07

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	63	
68948	63	
LG001	99	
67766	35	
68251	64	

8

D2739

Manufactured No

160 Each

4.0000 1 1



350 I Beam



1 BB 11/06/06

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	4	
67785	1	
68285	3	

69003

1

D3490-3

Manufactured No

160 Each

86.0000 4 4



Cross Bolt Spacer



BE 11/06/07

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	86	
68106	22	
68952	64	

4

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Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured

No

160

Each

49.0000

4

4



Cross Bolt Spacer



BE 4/6/07

Location

Loc Qty

Loc Code

LG

47

67773

5

68105

42

LG001

2

62450

2

1,617.000

38

38



ALS4-1032-225

Purchased

No

220

Each



Insert

Location

Loc Qty

Loc Code

ST282

1617

110768

817

117717 ✓

800

30.0000

1

1



38 BR 11-6-15.

D3793-3

Manufactured

No

230

Each



Wearshoe

Location

Loc Qty

Loc Code

FP018

21

68356 ✓

13

69283

8

FP019

9

64445 ✓

9

1 BR 11-6-15.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 5

Tuesday, May 24, 2011 8:25:04 AM

Work Order ID: 69872



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

69.0000

1

1



BOLT

LocationLoc QtyLoc Code

FP

40

117511

40

FP-A

29

115960

6

116874 ✓

23

1 BR 11-6-15

D3793-1

Manufactured

No

230

Each

31.0000

1

1



Wearshoe

LocationLoc QtyLoc Code

FP018

31

64445 ✓

14

69285

17

1 BR 11-6-15.

D3488-041

Manufactured

No

230

Each

21.0000

1

1



Blade Fitting Assembly, LH

LocationLoc QtyLoc Code

FP007

1

61689

1

FP008

20

62002

2

67788

6

68108 ✓

12

1 BR 11-6-15.

Tuesday, May 24, 2011 8:25:04 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 8:25:04 AM

Page 6

Work Order ID: 69872

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-3 Manufactured No

230 Each

34.0000 1 1



Gasket



Location

Loc Qty

Loc Code

FP010

26

68357 ✓

26

FP018

8

39422

1

61712

7

1 BR 11-6-15.

AN6C44A Purchased No

230 Each

113.0000 4 4



BOLT



Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

111

117407 ✓

80

117763

31

4 BR 11-6-15.

MS21083C8 Purchased No

230 Each

113.0000 1 1



NUT



Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST303

112

115884

0

117291 /

37

117423

50

117677

25

1 BR 11-6-15.

Tuesday, May 24, 2011 8:25:05 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 8:25:05 AM

Page 7

Work Order ID: 69872

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-25 Manufactured No

230 Each

34.0000 1 1



Gasket

Location

Loc Qty

Loc Code

FP012

34

65903

8

68351 ✓

26

D3631-1 Manufactured No

230 Each

500.0000 8 8



Washer

Location

Loc Qty

Loc Code

ST072

500

68062

500

D3791-1 Manufactured No

230 Each

19.0000 1 1



Wearplate

Location

Loc Qty

Loc Code

FP017

19

62239

7

68352 ✓

12

AN960C10L NAS1149C0332 ✓ Purchased No

230 Each

0.0000 38 38



washer

D2745 Manufactured No

230 Each

206.0000 8 8



Bushing

Location

Loc Qty

Loc Code

FP-A

206

67764

5

68248 ✓

201

Tuesday, May 24, 2011 8:25:05 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 8:25:05 AM

Page 8

Work Order ID: 69872

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 230 Each 1,586.000 34 34



Bolt



Location Loc Qty Loc Code

FP-A 7

115835 7

ST350 1579

115422 49

116419 334

116549 96

117343 500

117508 300

117764 300

34. BR 11-6-15.

D3537-1 Manufactured No 230 Each 34.0000 3 3



Wearpad



Location Loc Qty Loc Code

FP017 69817 34

63313 2

66804 28

66935 4

3 BR 11-6-15.

AN960C816L Purchased No 230 Each 0.0000 1 1



WASHER



NAS1149C0832R 114915

1 BR 11-6-15.

Tuesday, May 24, 2011 8:25:05 AM

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Page 8

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 8:25:05 AM

Page 9

Work Order ID: 69872

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 410.0000 4 4



BOLT

Location	Loc Qty	Loc Code
FP-A	1	
111982	1	
ST351	409	
111982	2	
116419	23	
116549	50	
116704	84	
117514 ✓	100	
117619	50	
117688	100	

4 BR 11-6-15

NAS1611-013 Purchased No 230 Each 168.0000 8 8



O-RING

Location	Loc Qty	Loc Code
FP	163	
117291	123	
117460 ✓	40	
FP-A	5	
116582	5	

8 BR 11-6-15

D3535-25 Manufactured No 230 Each 30.0000 1 1



Wearshoe

Location	Loc Qty	Loc Code
FP018	30	
62233	1	
65167	3	
68353	11	
69284 ✓	15	

1 BR 11-6-15

Tuesday, May 24, 2011 8:25:05 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 8:25:06 AM

Work Order ID: 69872

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-1 Manufactured No

230 Each

32.0000

1

1



Gasket



Location

Loc Qty

Loc Code

FP010

32

39421

1

61704

5

68355

26

Purchased No

230 Each

523.0000

4

4

MS21043-6



NUT



Location

Loc Qty

Loc Code

FG

20

103693

20

FP-A

40

112314

40

ST301

463

112314

463

Manufactured No

250 Each

72.0000

2

2

D3493-1



Washer



Location

Loc Qty

Loc Code

ST062

72

66975

31

68253

41

1 BL 11-6-15

4 BL 11-6-15

11/6/16 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 8:25:06 AM

Work Order ID: 69872

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

113.0000

2



NUT

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST303

112

115884

0

117291

37

117423

50

117677

25

AN8C21A

Purchased

No

250

Each

101.0000

2



BOLT

Location

Loc Qty

Loc Code

ST344

25

117764

25

ST345

76

116381

26

117562

50

NAS1515H3L

Purchased

No

230

Each

276.0000

8



WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

236

113362 ✓

236

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 12

Tuesday, May 24, 2011 8:25:06 AM

Work Order ID: 69872

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250 Each

44.0000

1

1



Blade, 350 Skidtube



SD

Location

Loc Qty

Loc Code

ST466

44

61341

6

63589

38

Manufactured No

250 Each

35.0000

2

2

D3532-1



Spacer



11/6/16SD

Location

Loc Qty

Loc Code

ST065

35

62218

13

66949

22

Tuesday, May 24, 2011 8:25:06 AM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69877

11-05-24

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEQ 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PC		
DRAWN	RL		
CHECKED	RL		
MFG. APPR.	AS		
APPROVED	MT		
DE APPR.	MT		
DATE	08.07.16		
DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWING NO. D2750		REV. F SHEET 1 OF 11	
TITLE 350 SKIDTUBE ASSEMBLY		SCALE NTS	
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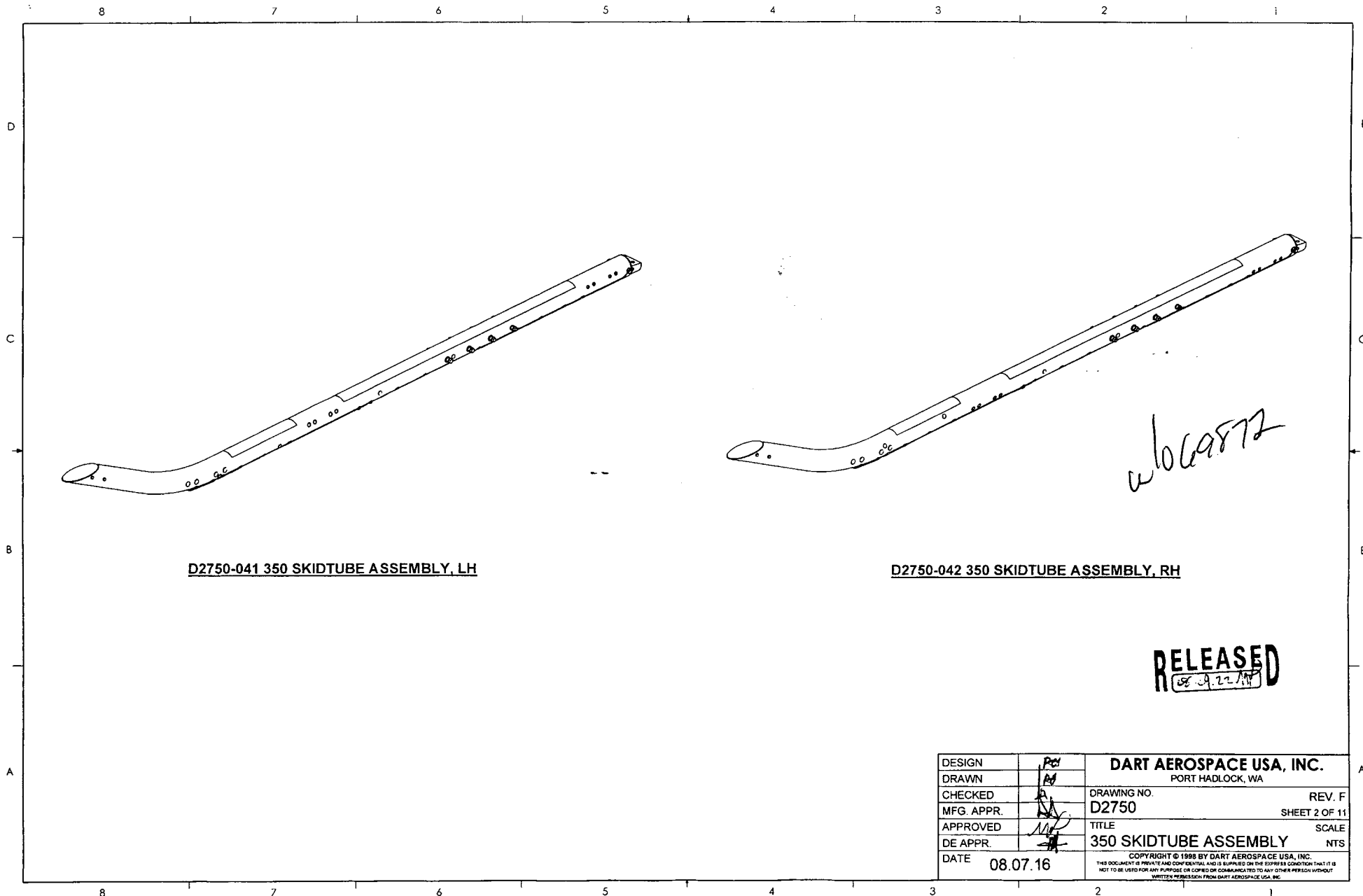
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



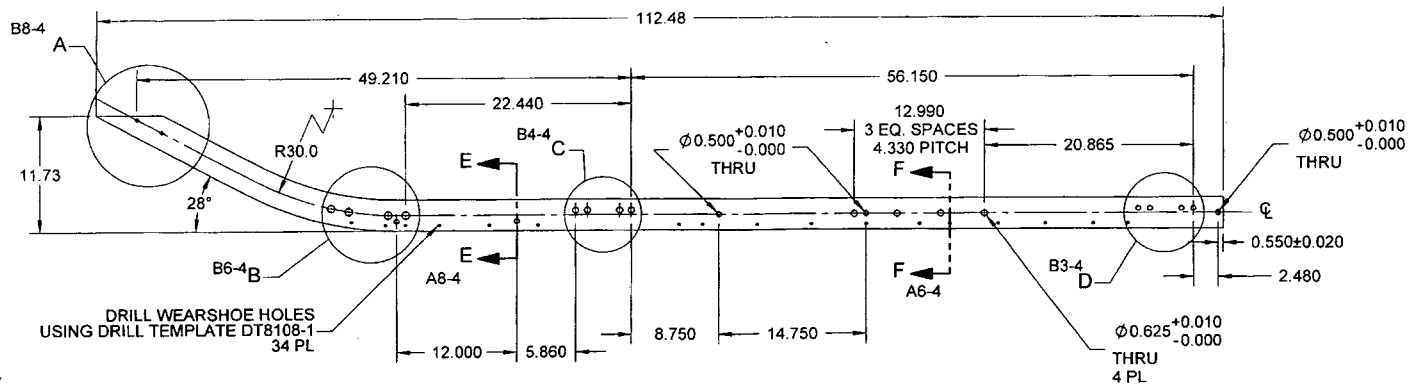
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

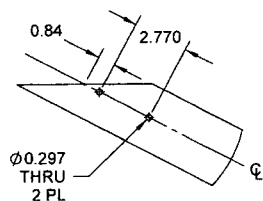
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

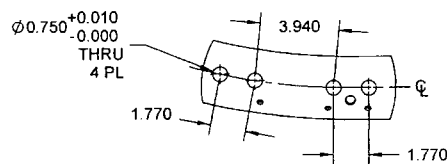
NOTE: Date & initial all entries



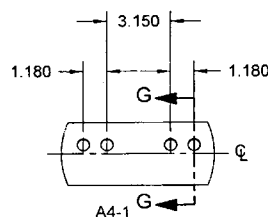
D2750-1 LH SKIDTUBE



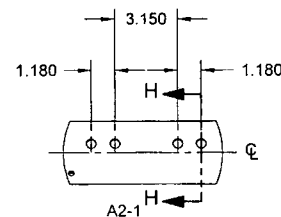
DETAIL A
SCALE 2X



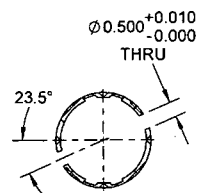
DETAIL B
SCALE 2X



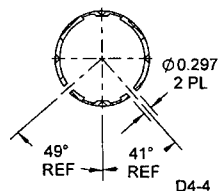
DETAIL C
SCALE 2X



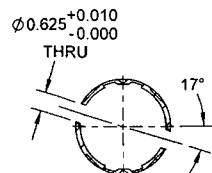
DETAIL D
SCALE 2X



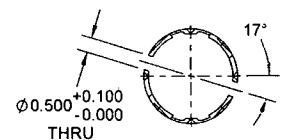
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

RELEASED

DESIGN	IPB	DART AEROSPACE USA, INC.	
DRAWN	IPB	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 254

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 69872
Part number: A350 636 011
Description: 350
Welding Process: Tig ☒ Mig ☐
Base material: aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat Lewis Date of Test Coupon 11.06.08
Welder Barclay Elliot Date of Test Coupon 11/06/08

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries